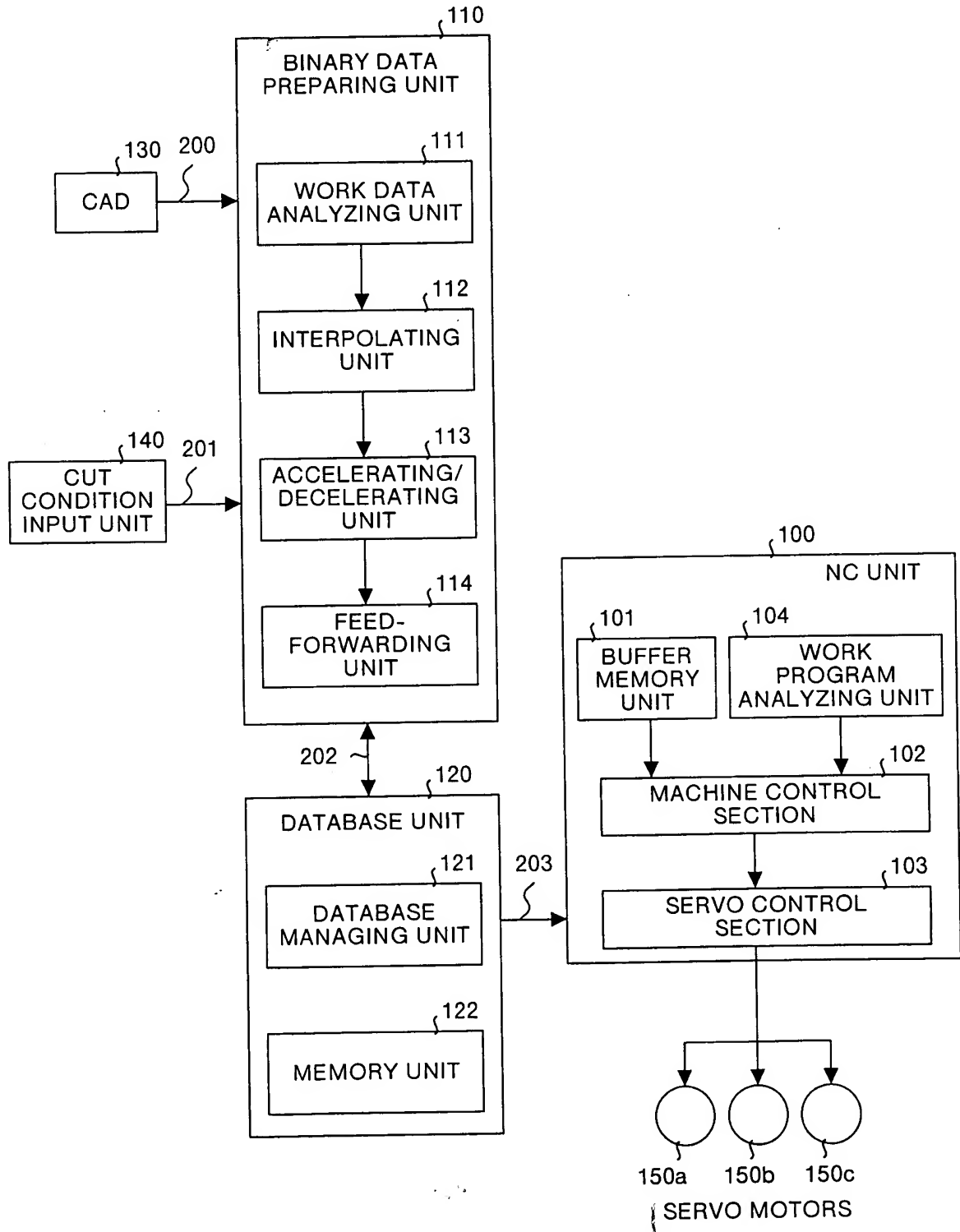
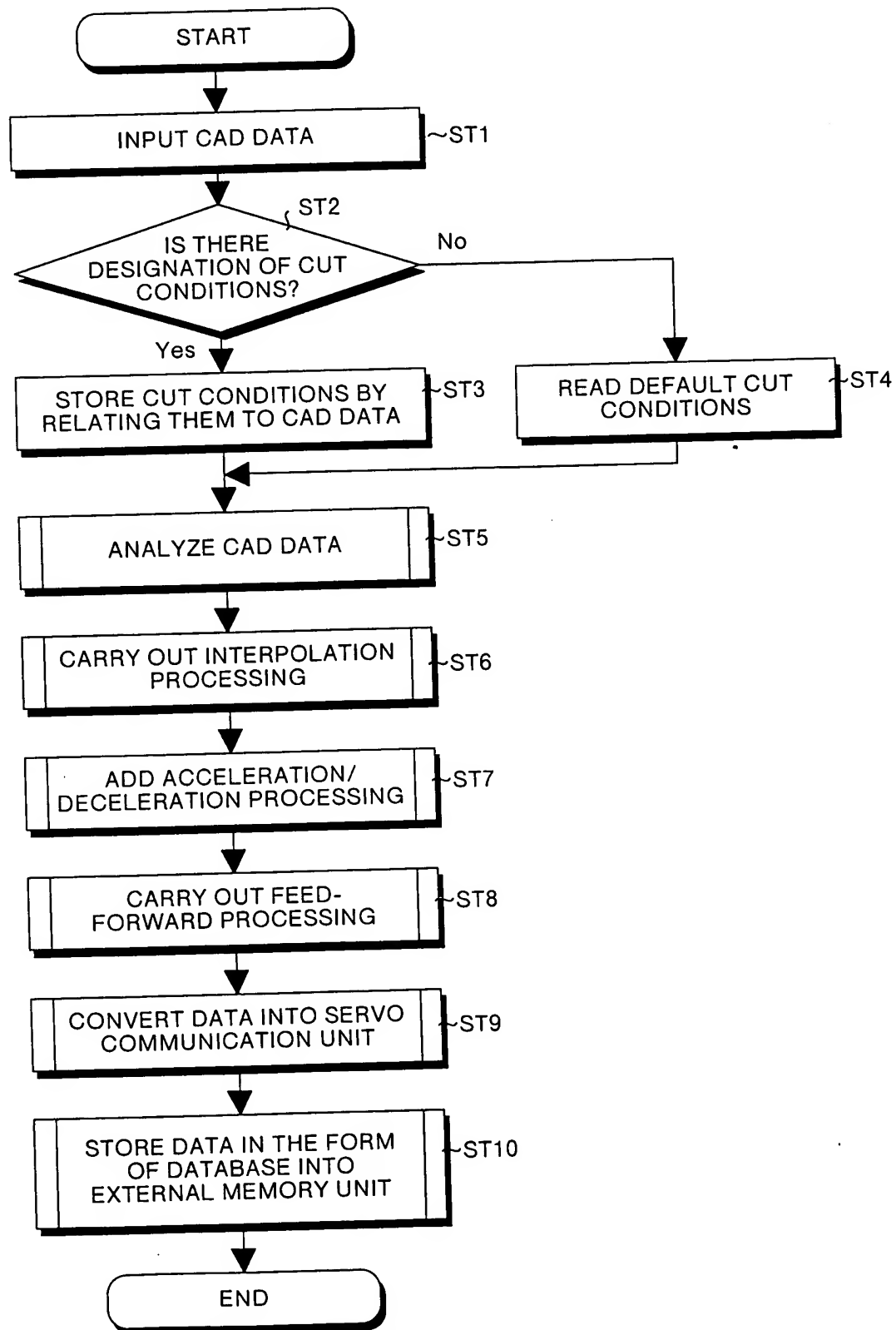


FIG.1



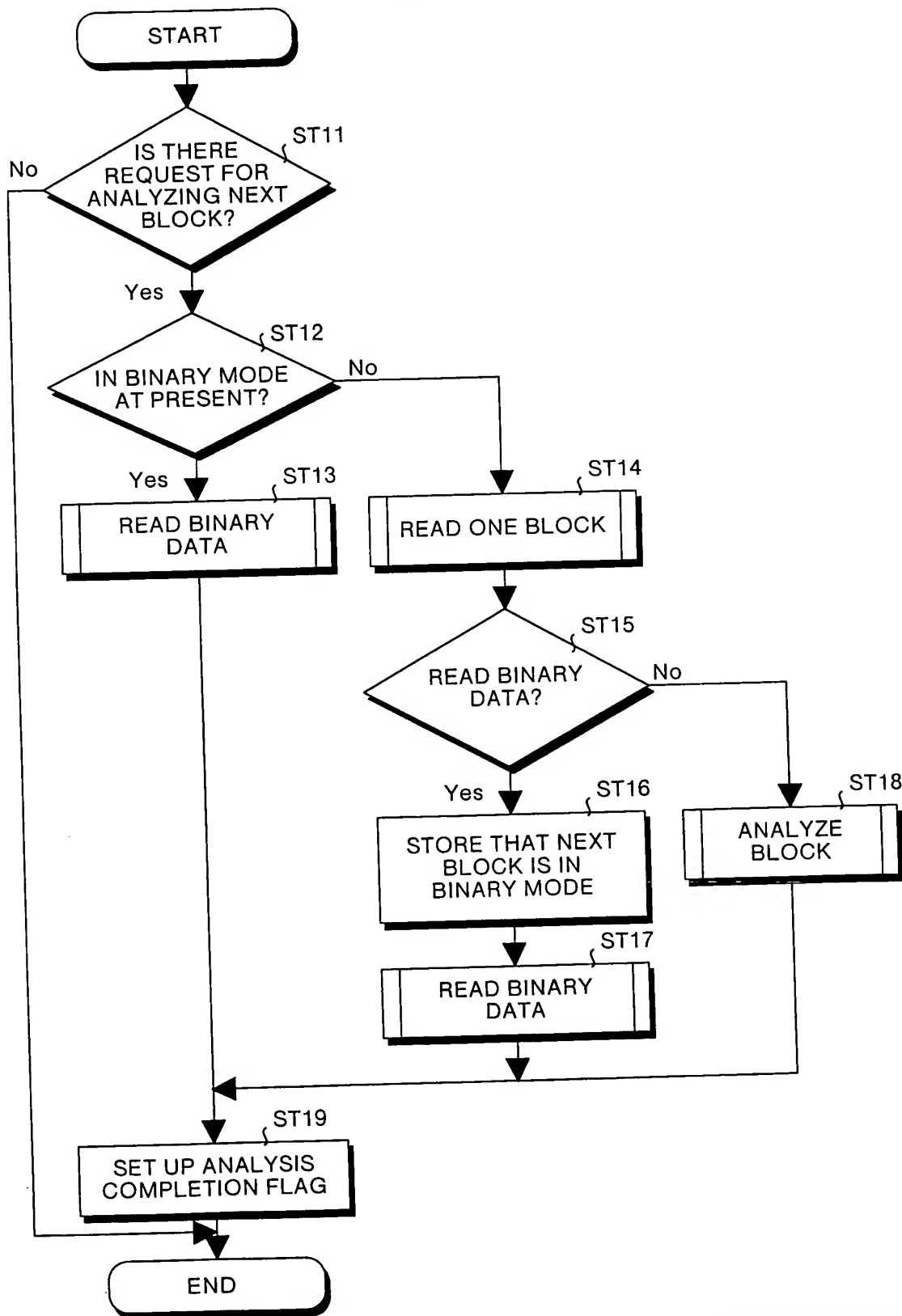
2/14

FIG.2



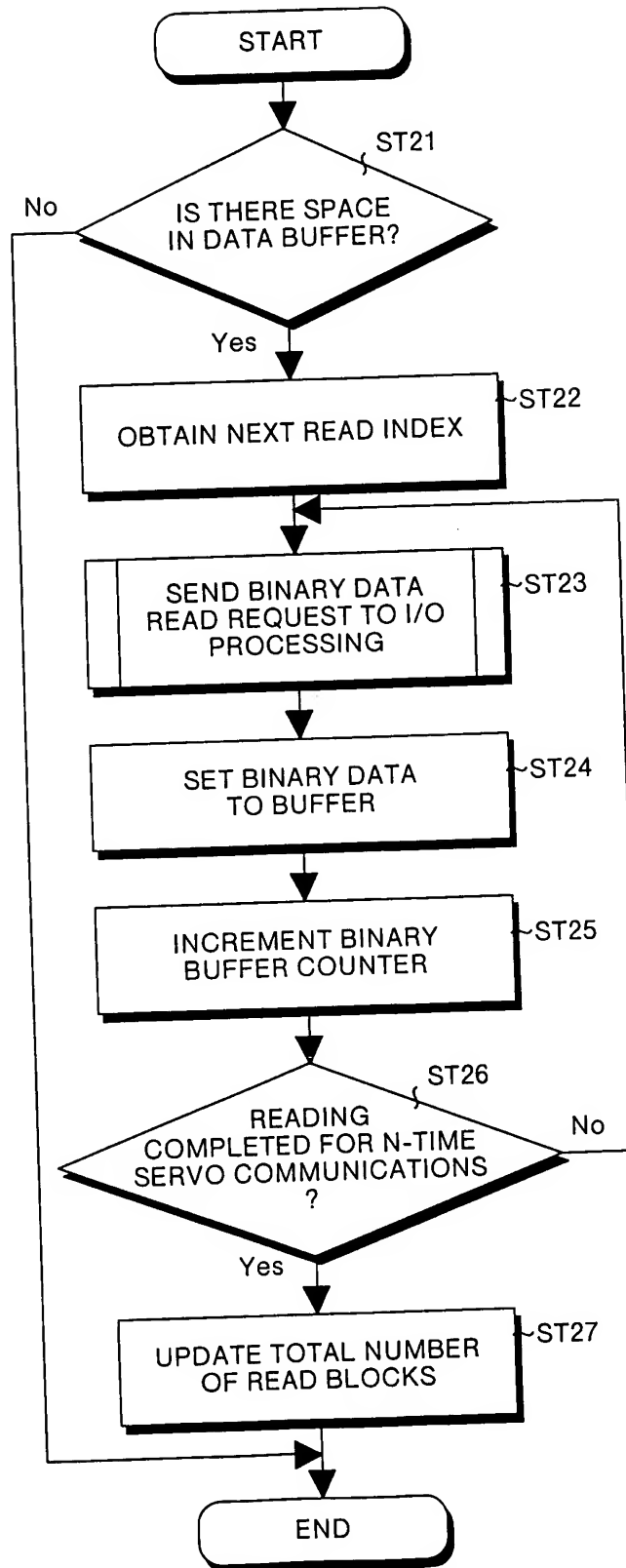
3/14

FIG.3



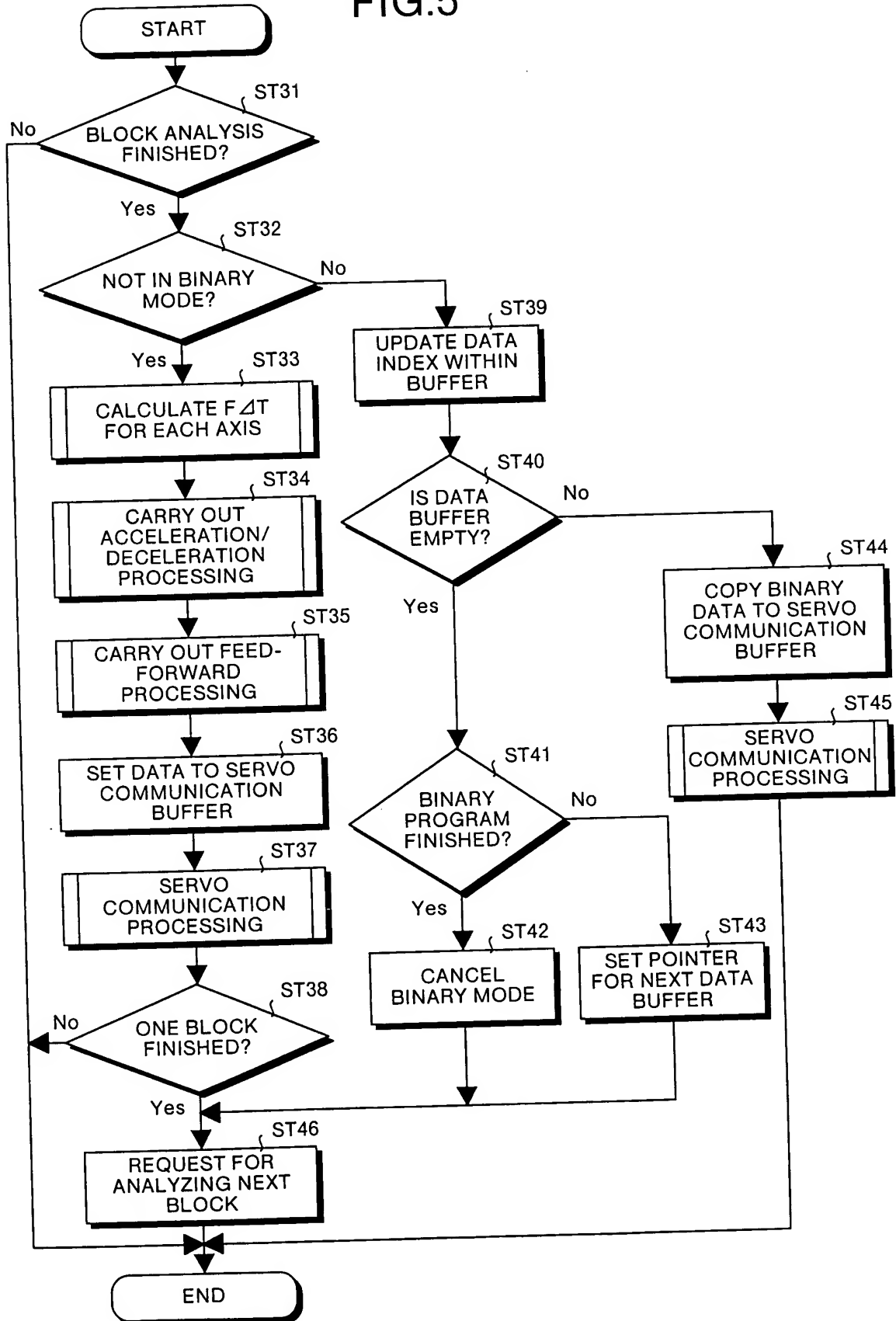
4/14

FIG.4



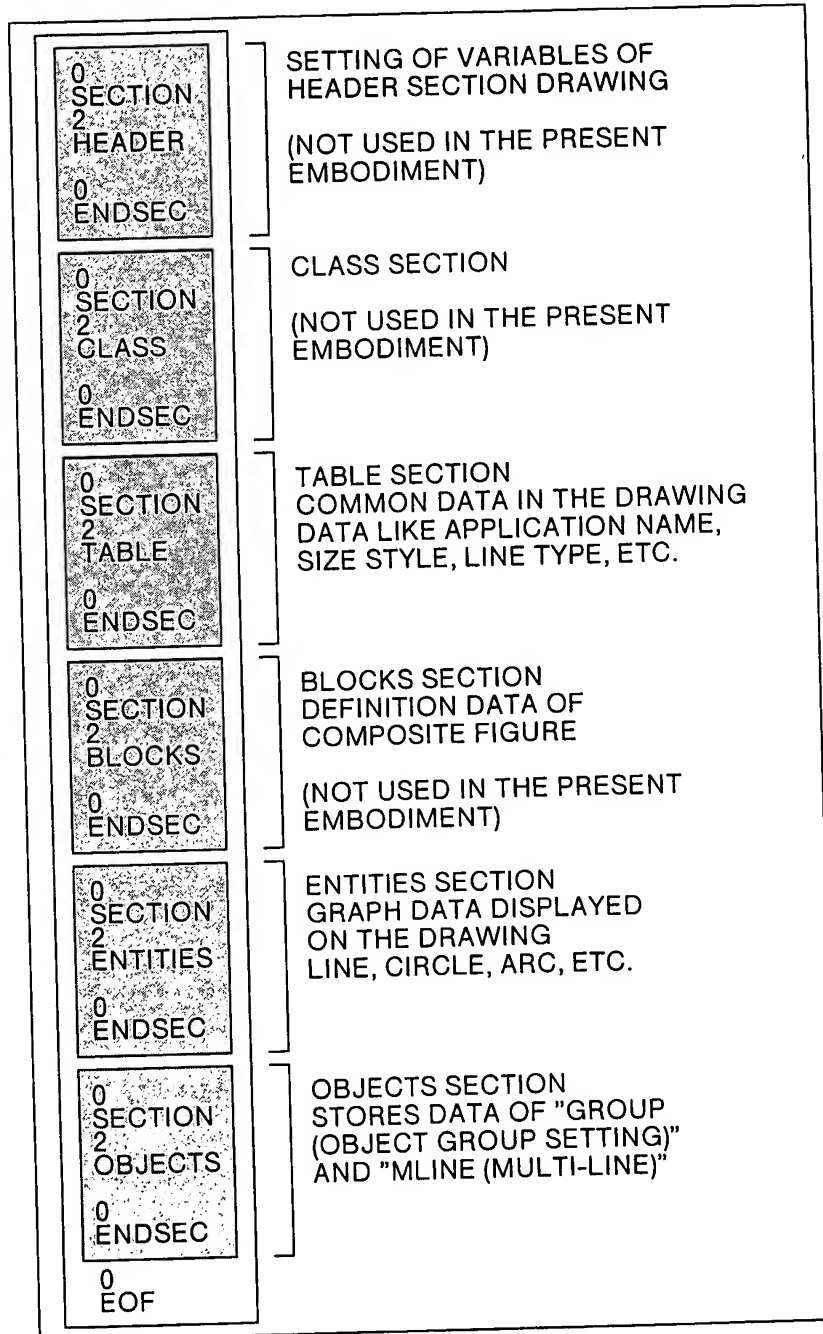
5/14

FIG.5



6/14

FIG.6



7/14

FIG.7

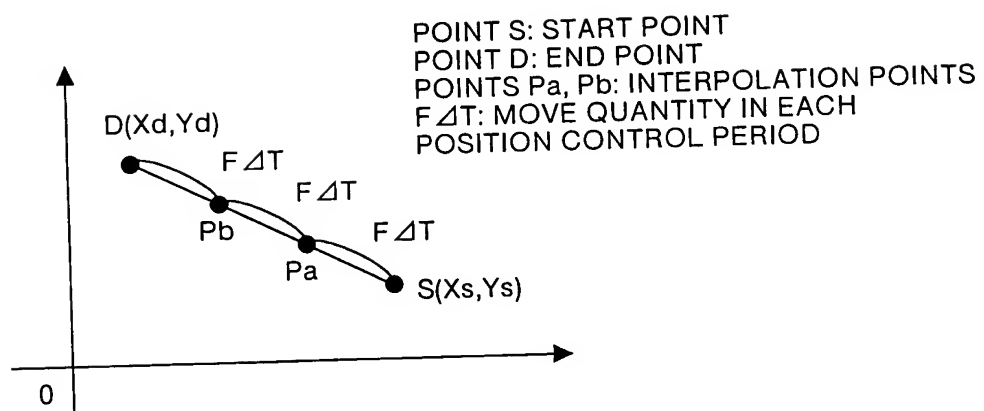


FIG.8

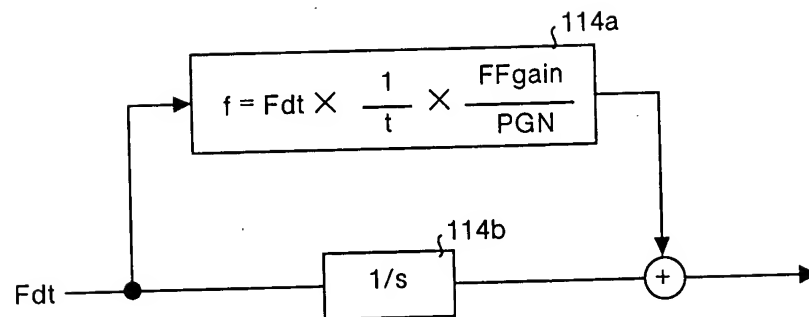
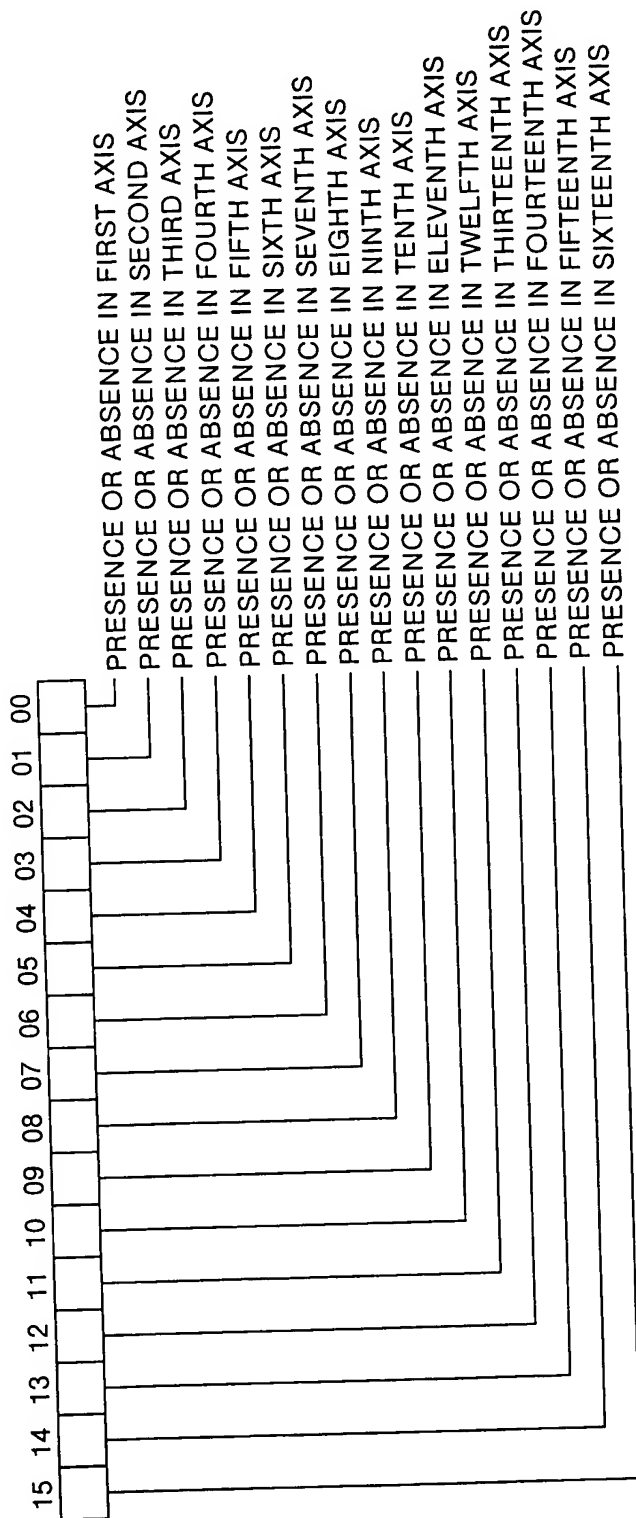


FIG.9

TOTAL NUMBER OF BLOCKS OF BINARY PROGRAMS	
NUMBER OF BLOCKS	
HEADER BLOCK NUMBER	
AXIS DESIGNATION FLAG	
ABSOLUTE POSITION COMMAND	
INTERPOLATION FΔT1	INTERPOLATION FΔT2
INTERPOLATION FΔT3	INTERPOLATION FΔT4
INTERPOLATION FΔT5	INTERPOLATION FΔT6
INTERPOLATION FΔT7	INTERPOLATION FΔT8
ABSOLUTE POSITION COMMAND	
INTERPOLATION FΔT1	INTERPOLATION FΔT2
...	
INTERPOLATION FΔT7	INTERPOLATION FΔT8
CHECK SUM	

DATA FOR ONE
AXIS OF SERVO
COMMUNICATION

FIG.10



11/14

FIG.11

```
G00 G90 X120. Y100.;  
G94 S1000;  
G65 P100, R1; ] CONTROL BASED ON BINARY PROGRAM  
G65 P101, R1; ]  
G00 X120. Y150.;  
M30;  
%
```

12/14

FIG.12

122

DATABASE

TABLE INFORMATION MANAGEMENT TABLE	CAD DATA INFORMATION TABLE	BINARY INFORMATION TABLE
TABLE NUMBER ID	CAD DATA ID	BINARY DATA ID
TABLE NAME	CAD DATA NAME	BINARY DATA NAME
DATE AND TIME OF PREPARATION	PLANE INFORMATION	NUMBER OF ROTATION OF MAIN AXIS
DATE AND TIME OF UPDATING	INTERPOLATION INFORMATION	FORWARDING SPEED
VERSION INFORMATION		mm/inch
OFFSET		SYNCHRONOUS/ ASYNCHRONOUS
		PROCESSING STARTING POSITION
		CUT DIRECTION
		ACCELERATION/ DECELERATION TIME CONSTANT
		ROTATION DIRECTION OF MAIN AXIS
		NC UNIT NUMBER

FIG.13

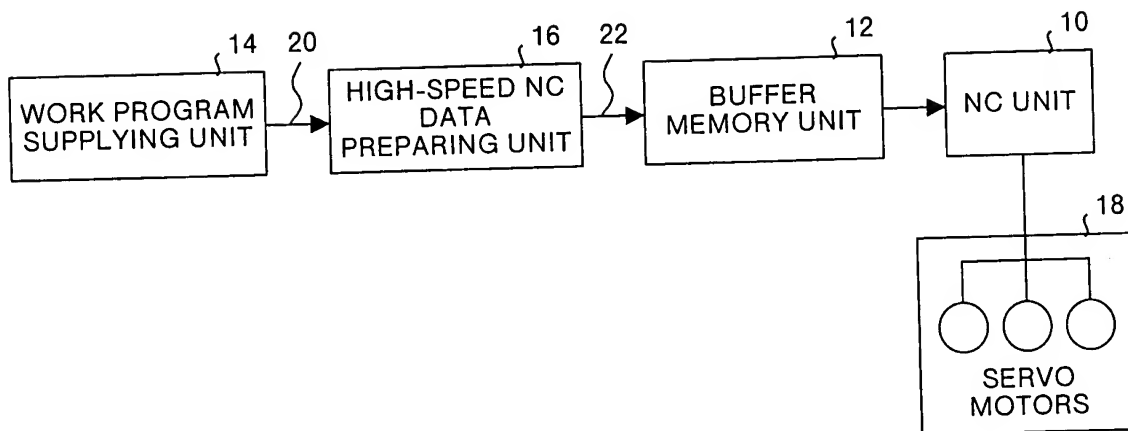


FIG.14

